

Work Order ID 68725

Wednesday, April 20, 2011 10:23:00 AM



Page 1

Item ID: D4293-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 4/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4293	C

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut Blank to 6.850"

Batch: M116930

GRAIN ALONG 4"**

cm 11/06/21

4 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine per folio FB005

DWG REV: C

FOLIO REV: AA

SA 11/06/21

4 4

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

B.A 11/06/21

4

/

Quality Control

121

Memo

0.00



Mill Conv

Memo

0.00

CMT 11/06/22

4

/

Conventional Milling Machine

DRILL & TAP FOR HELICOIL AS PER DWG

122

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

CMT 11/06/22

4

/

Quality Control

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

52 11/06/23



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 BR 11-6-23

145

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

MASK THREADED HOLE

Start Time: 9:15

Temp: 320°F

Finish Time: 9:45

4 X of M 11/06/23

M 11/06/23

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

146

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

H BL 11-6-23

148

Small Fab
Small Fab
INSTAL HELICOIL AS PER DWG

0.00



Small Fab

Memo

0.00

Small Fab

EFB 11/06/23

149

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/23

XL

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

Identify as per dwg & Stock Location: ST 48

0.00

Memo

0.00

Packaging

u 11-06-23 (4)

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/6/23 dfmc11-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Wednesday, April 20, 2011 10:23:08 AM

Page 1

Work Order ID: 68725

Parent Item: D4293-1

Parent Item Name: Fitting



Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-15 JLM VERIFIED BY:DD IPP REV
B: AS PER REV B 11-02-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21209F1-10		Purchased	No				Each	92.0000		4			
--------------	--	-----------	----	--	--	--	------	---------	--	---	--	--	--



HELI COIL

Location

Loc Qty

Loc Code

ST305

92

116977

92

M7075T73B4.000x4.00

Purchased

No

f

19.1210

2.4

0



7075-T73 Bar 4.0 x 4.0

Location

Loc Qty

Loc Code

MAT005

19.121

116153

0.75

116324

7.95

116764

6

116867

0.041

116930

4.38

2.4

4/20/2011

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 68725
Description: FITTING		Part Number: D4293-1
Inspection Dwg: D4293 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.305	+0.030/-0.010	0.314	✓		GA-01	Vern
R0.063	+/-0.010	R0.063	✓		R-6	ref.
0.125	+0.030/-0.010	0.133	✓		Vern	GA-01
0.88	+/-0.030	0.886	✓		"	"
0.500	+/-0.010	0.491	✓		"	"
0.82	+/-0.030	0.820	✓		"	"
0.39	+/-0.030	0.394	✓		"	"
0.088	+/-0.010	0.089	✓		D-6	GA-08
0.625	+/-0.010	0.629	✓		Vern	GA-01
1.730	+/-0.010	1.732	✓		H-6	31006
0.800	+/-0.010	0.799	✓		Vern	GA-01
0.275	+/-0.010	0.276	✓		"	"
1.13	+/-0.030	1.128	✓		"	"
3.11	+/-0.030	3.122	✓		"	"
3.44	+/-0.030	3.440	✓		"	"
2.450	+/-0.010	2.450	✓		"	"
1.325	+/-0.010	1.326	✓		"	"
0.305	+/-0.010	0.301	✓		"	"
2.84	+/-0.030	2.836	✓		"	"
5.86	+/-0.030	5.864	✓		"	"
6.52	+/-0.030	6.527	✓		Vern	CUC-02
0.19	+/-0.030	0.190	✓		Vern	GA-01
φ0.272	+0.006/-0.007	φ0.273	✓		"	"

Measured by: B.A. / JAK	Audited by: J.L.	Preliminary Approval:
Date: 11/06/21	Date: 11/06/23	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD		Work Order: 68725
Description: FITTING		Part Number: D4293-1
Inspection Dwg: D4293 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ0.323	+ .006 - .001	φ0.324	✓		Vern	GA-01
1.75	+/- .030	1.754	✓		"	"
R0.25	+/- .030	R0.250	✓		R-6	ref.
4.875	+/- .010	4.875	✓		Vern	GA-01
0.493	+/- .010	0.494	✓		"	"
φ0.201	+ .005 - .001	φ.202	✓		"	ML-7
0.800 dp.	+/- .010	.800	✓		"	"
CSK φ0.320 X 100°	+/- .010	φ.330 X 100°	✓		"	"
0.663	+/- .010	.661	✓		"	"
CBORE φ0.765	± .010	φ0.7655	✓		Vern	CNC-02
6.20	+/- .030	6.192	✓		"	"
R0.13	+/- .030	R0.125	✓		R-6	Ref.
1.125	+/- .010	1.125	✓		Vern	ML-7
φ0.381	+0.000/-0.001	φ.381	✓		"	"
1.388	+/- .010	1.389	✓		"	"
R0.031	+/- .010	R0.032	✓		R-6	Ref.
4.500	+/- .010	4.500	✓		Vern	GA-01
R1.370	+/- .010	R1.370	✓		R-6	ref.
2.250	+/- .010	2.251	✓		H-6	31006
0.680	+/- .010	0.680	✓		Vern	GA-01
1.65	+/- .030	1.657	✓		"	"
1.42	+/- .030	1.420	✓		"	"

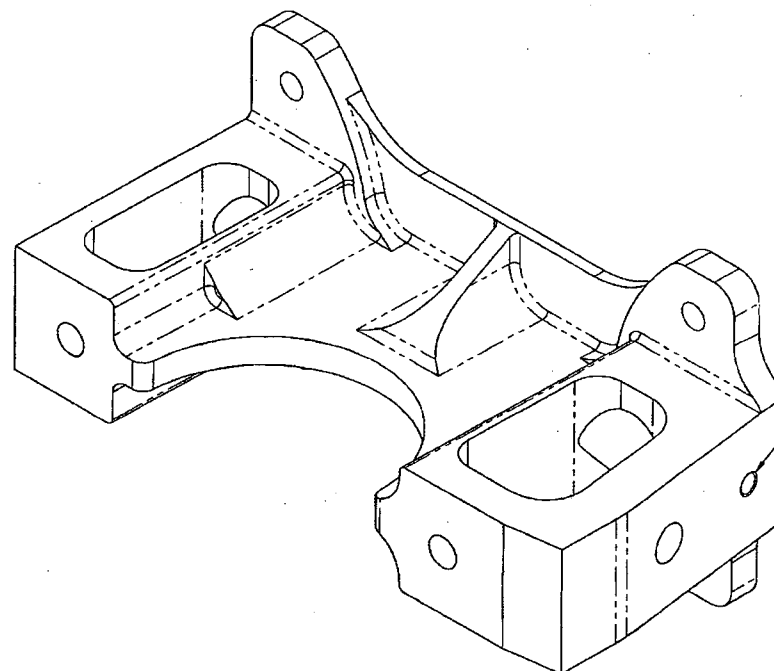
Measured by: H.A. / <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 11/06/21	Date: 11/06/23	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68725

211-04-20



MS21209F1-10 HELICAL COIL, 1X
REF

GRAIN
DIRECTION

D4293-1 FITTING

RELEASED
2011-02-01
[Signature]

NOTES:

- 1) MATERIAL: 7075-T731/-T73510/-T73511 BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4293-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.18 lbs

C	ADD HELICAL COIL (D1-2, B4-3)	CP	11.01.14
B	0.800 WAS 0.78 (C8-2), 1.730 WAS 1.72 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	<i>[Signature]</i>		
CHECKED			
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.01.14		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4293	REV. C
TITLE FITTING (206L AFT)	SHEET 1 OF 3
SCALE NTS	

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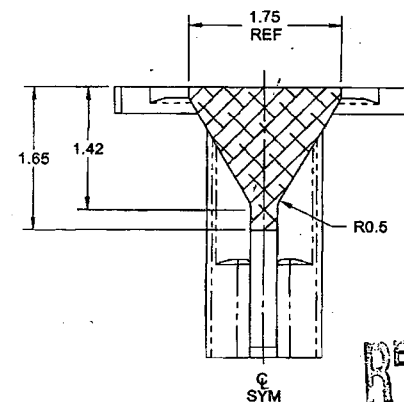
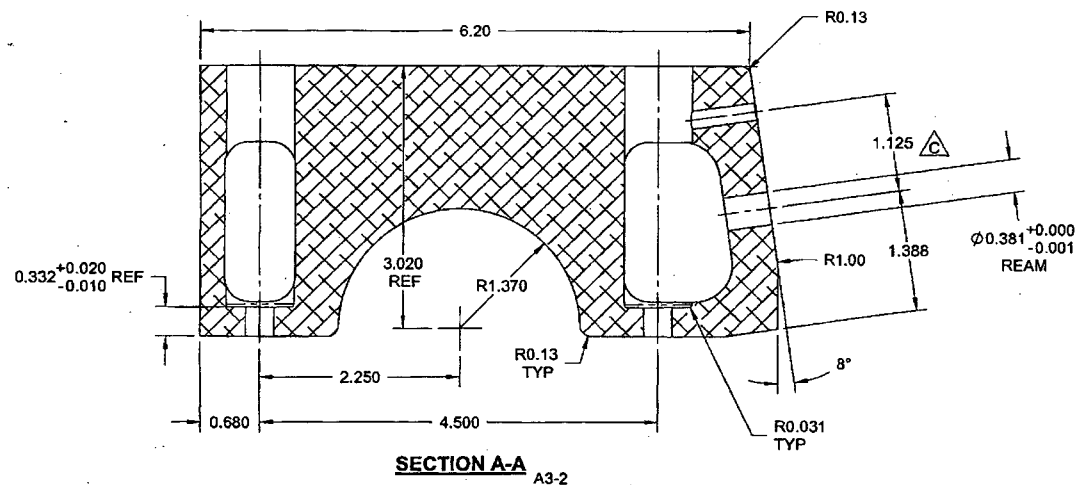
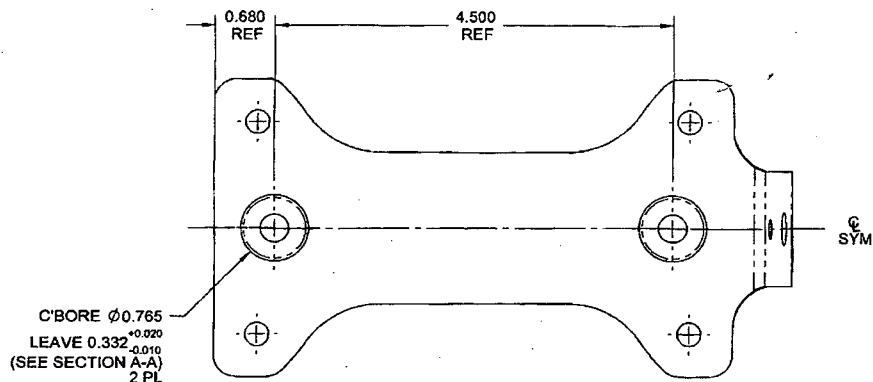
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wlo 68725

RELEASED
2011-02-11

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4293	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FITTING (206L AFT)	NTS
DATE	11.01.14	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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